

Work Order ID 129909

February-23-15 10:31:56 AM

129909

Page 1

Item ID: D412-760-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cabin Floor Protector
 Start Date: 2/17/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 15-02-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D412-760	G	<u>SD</u>

100	Document Control	0.00	DAS						
100	DOCUMENT CONTROL		46						
DC	Memo	0.00	9-89						
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-760-011 CHG002								

MAR 24 2015

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS 27 9-89
 DAS 6 9-89

MAR 21 2015

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 46 9-89

MAR 24 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other	Pressure/Forced
☐ Bending	☐ Bend	☐ Folio/Program	☐ Set-up
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Weld
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	
☐ Crushing	☐ Countersink	☐ Misaligned/off center	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	

DQA: _____ Date: _____



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Material									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 129909

129909

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 2/17/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 07.07.05 new issue EC
IPP Rev:B 08-08-20 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3574-1 *D3574-1* Cabin Floor Protector	DAS 46 9-89	Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89 27 9-89
D3574-2 *D3574-2* Cabin Floor Protector	DAS 46 9-89	Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89 27 9-89
D3575-1 *D3575-1* Cargo Floor Protector	DAS 46 9-89	Manufactured	No			110	Each	1.0000	1	1			DAS 6 9-89 27 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				PKG			1						
				127378			1						
D3575-2 *D3575-2* Cargo Floor Protector	DAS 46 9-89	Manufactured	No			110	Each	1.0000	1	1			DAS 6 9-89 27 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST500			1						
				118463			1						
D3580-1 *D3580-1* Joggle Bracket	DAS 46 9-89	Manufactured	No			110	Each	39.0000	6	6			DAS 6 9-89 27 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST050			20						
				127565			20						
				ST051A			19						
				121071			19						

MAR 21 2015

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 129909

129909

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 2/17/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

D3628-1 Manufactured No 110 Each 605.0000 14 14

D3628-1

Washer, Cupped

DAS
46
9-89

**

Location

Loc Qty

Loc Code

FG

10

83587

10

ST052A

500

123627

500

ST053

95

116783

95

1

13

DAS
DAS 27
6 9-89
9-89

D3628-3

D3628-3

Cupped Washer

DAS
46
9-89

Manufactured No

110 Each

245.0000 6 6

**

Location

Loc Qty

Loc Code

ST051A

166

96308

166

ST053

79

96308

79

6

DAS
27 9-89
DAS
6 9-89

MS24694-S100

MS24694-S100

Flat Head Screw

Purchased

No

110 Each

78.0000 6 6

**

Location

Loc Qty

Loc Code

ST288

78

m131317

78

6

DAS
MAR 21 2015
DAS 27 9-89
9-89

DQA: _____ Date: _____



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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Work Order ID: 129909

129909

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 2/17/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

MS24694-S54

Purchased

No

110

Each

58.0000

14

14

DAS 6
27-89

MS24694-S54

DAS

46

SCREW

9-89

**

mass3578

Location

Loc Qty

Loc Code

ST022

2

117460

2

ST289

56

113359

6

m130928

50

6x

NAS1149D0363J

Purchased

No

110

Each

3,034.000

28

28

**

NAS1149D0363.J

DAS

46

Washer

9-89

Location

Loc Qty

Loc Code

CA

577

m130799

577

FP001

31

113288

14

m126319

17

GA

426

m128429

426

ST269

2000

m131618

2000

MAR 21 2015

DAS 6
27-89
DAS 6
27-89

28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 2/17/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

5,594.000

12

12

NAS1149D0463.J DAS

WASHER

46

9-89

**

DAS 27 DAS 6
5-89 9-89

MAR 21 2015

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1151

M129390

1151

ST269

3638

M130799

638

M131624

3000

12

DQA: _____ Date: _____



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Ref.

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D412-760-011	CABIN FLOOR PROTECTOR KIT
	X				D412-760-013	CABIN FLOOR PROTECTOR KIT
		X			D412-760-015	CABIN FLOOR PROTECTOR KIT
			X		D412-760-017	CABIN FLOOR PROTECTOR KIT
				X	D412-760-019	CABIN FLOOR PROTECTOR KIT
1					D3574-1	CABIN FLOOR PROTECTOR
1					D3574-2	CABIN FLOOR PROTECTOR
	1				D3574-3	CABIN FLOOR PROTECTOR
	1				D3574-4	CABIN FLOOR PROTECTOR
		1			D3574-5	CABIN FLOOR PROTECTOR
		1			D3574-6	CABIN FLOOR PROTECTOR
1					D3575-1	CABIN FLOOR PROTECTOR
1					D3575-2	CABIN FLOOR PROTECTOR
	1				D3575-3	CABIN FLOOR PROTECTOR
	1				D3575-4	CABIN FLOOR PROTECTOR
		1			D3575-5	CABIN FLOOR PROTECTOR
		1			D3575-6	CABIN FLOOR PROTECTOR
6	4	6	6	6	D3580-1	JOGGLE BRACKET
			1		D3788-1	CABIN FLOOR PROTECTOR
			1		D3788-2	CABIN FLOOR PROTECTOR
			1		D3788-3	CABIN FLOOR PROTECTOR
			1		D3788-4	CABIN FLOOR PROTECTOR
14	40	14	14	10	D3628-1	CUPPED WASHER
6	8	6	6		D3628-3	CUPPED WASHER
				1	D4122-1	FLOOR PROTECTOR, FORWARD
				1	D4122-3	FLOOR PROTECTOR, AFT
28		28	28		NAS1149D0363J	WASHER (AN960JD10)
12		12	12		NAS1149D0463J	WASHER (AN960JD416)
14		14	14		MS24694S54	SCREW
6		6	6		MS24694S100	SCREW